

Date: Friday, 12/21/2007 7:27:45 AM
User: Kim Johnston

Process Sheet

431.8

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ARM
Job Number : 36522	
Estimate Number : 11488	
P.O. Number :	Part Number : D31651
This Issue : 12/21/2007 S.O. No. :	Drawing Number : D3165 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 34988	Material :
Written By :	Due Date : 1/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JA 071221</u>	
Comment : Est. A 02.09.18 New issue KJ	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



7.482

Comment: Qty.: 1.4963 f(s)/Unit Total : 14.9625 f(s)
6061-T6 Bar .50" x 5.0"
Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) per (M6061T6B0.500x5000)
Batch M106182

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut Blank: (17.00" x 5.00") +/- 0.030" x 0.500" thick
Grain along 17.000"

SA 08/02/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA277 & Dwg D3165-1
Deburr & Tumble

SA 08/02/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/02/24

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JIF 08/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/21/2007 7:27:45 AM
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Drawing Name: SUPPORT ARM

Job Number: 36522

Part Number: D31651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Engrave batch number as per Dwg D3165

CP 08/02/27 (5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

M.L. 08/02/27

(5X)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 107005

F2 08/02/27

(5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-27

(45)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

157

8/3/3

SC

(5X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 08/03/04

(5)

Job Completion



2008/3/04 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

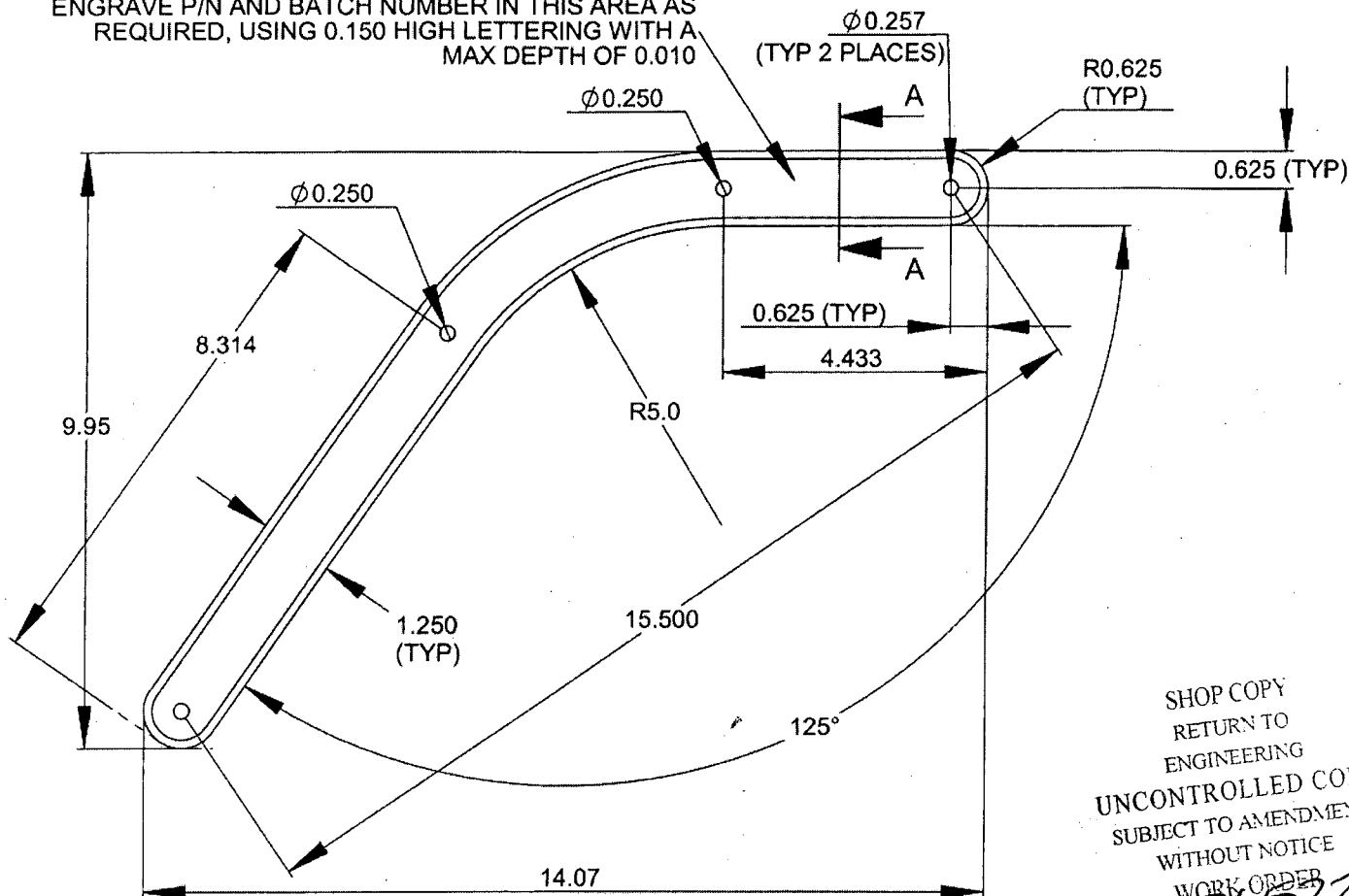
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



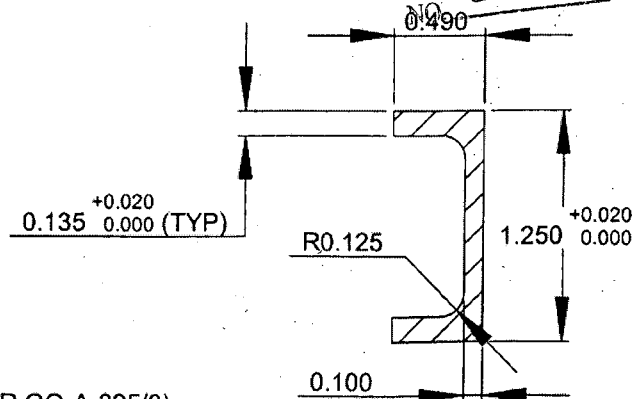
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3165	REV. A SHEET 1 OF 1
DATE 02.07.09		TITLE SUPPORT ARM	SCALE 1:3
A	02.07.09	NEW ISSUE	

ENGRAVE P/N AND BATCH NUMBER IN THIS AREA AS REQUIRED, USING 0.150 HIGH LETTERING WITH A MAX DEPTH OF 0.010



RELEASED
02.08.07

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
36522



D3165-1 SUPPORT ARM

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) PER M6061T6B
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SECTION A-A
SCALE (1 : 1)

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